

Work Order ID 65303 - 2

January 11, 2011 9:21:10 AM



Page 1

Item ID: D3315-4

Revision ID:

Item Name: Wearplate

Start Date: 1/18/11

Start Qty: 6.00

Required Date: 1/31/11

Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 11-01-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3315

Rev B

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3315
Deburr if necessary

Dwg Rev: B

Prog Rev: B

2-

AB 11-2-14

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

AB 11-2-14

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

5/12/14

HL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65303

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Page 2

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Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B S/B 1/16/11



140



QC

QC 6- Inspect dimensions to drawing

0.00

Memo

0.00

Quality Control

S/B 1/16/11



150



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

Weld hard surface using D3315-4T3 as per QSI 004 and Dwg D3315 Rev:

Qty Part Number Description Batch A/R

N/A 7560 Hardcoat Rod 11/16/11

11-2-25 (L3)

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Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8/162/28

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/162/28

Quality Control

(X3)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

START TIME:

8:30

FINISH TIME:

320°F

OVEN TEMPERATURE:

9:00

Powder Coating

(3X) m.f. 11/03/01

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

3 BR 11-3-1

200

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following: (TCCA-PDA, Dart Aerospace Ltd.) P/N: D3315-4, B/N: BXXXXX (For Product Eligibility see PDA04-17 and Stock Location: 4976

11/21 SP 130

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/02 11/03/02

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Picklist Print

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Parent Item: D3315-4

Parent Item Name: Wearplate



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Required Qty: 6.00

Comments: IPP: A 05.05.12 New issue KJ/JLM
IPP Rev:B As per Rev B 06-03-24 JLM
IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA



1010/1025 sheet 16GA

Purchased

No

100

sf

13.9250

2.296

14.50105



B 11-2-14

Location

Loc Qty

Loc Code

MAT19

13.925

111410

13.925

116791

116791

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

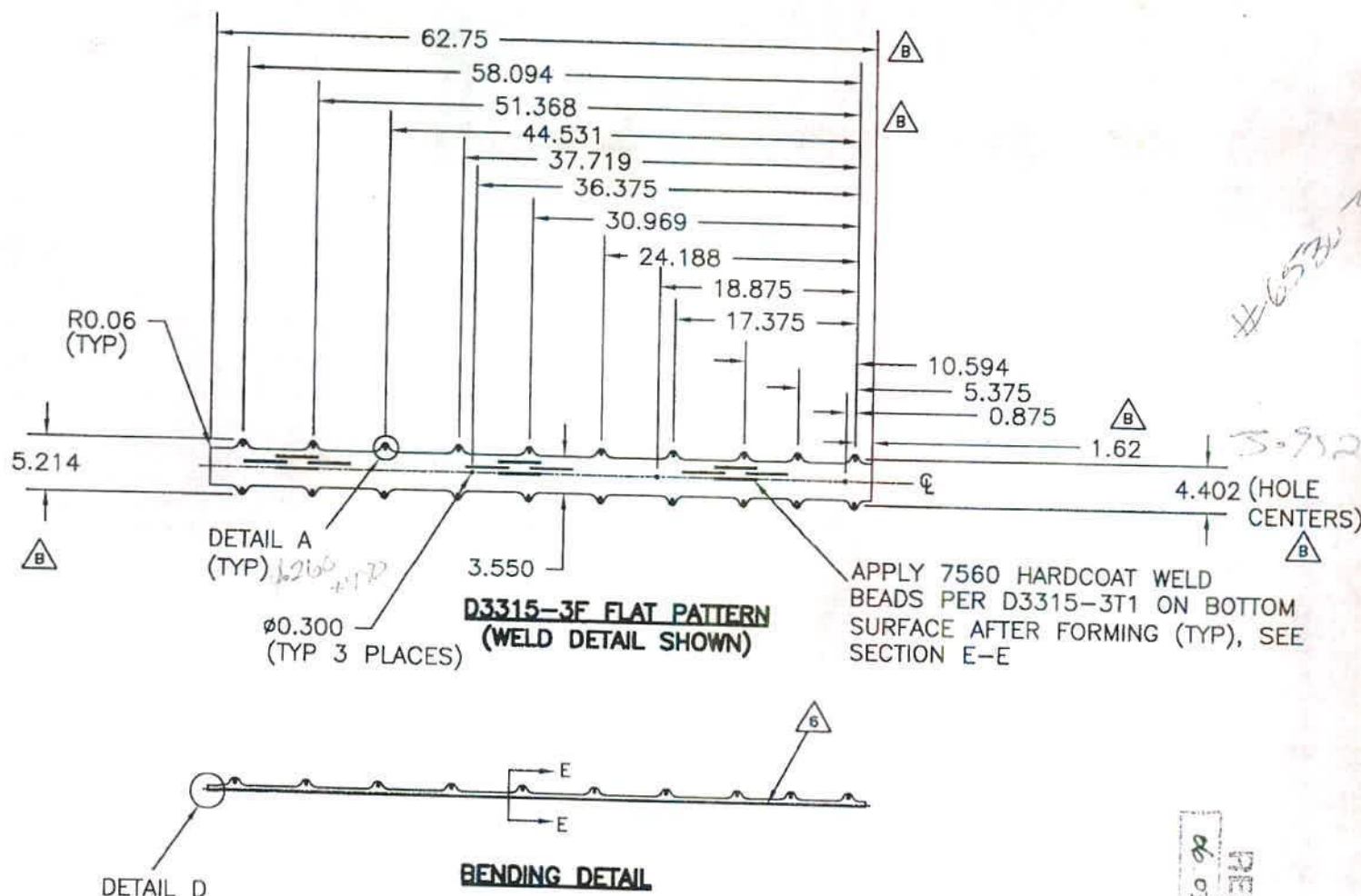
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3315
DATE	06.01.31	TITLE	WEARPLATE	REV. B SHEET 2 OF 4
		SCALE	1:16	



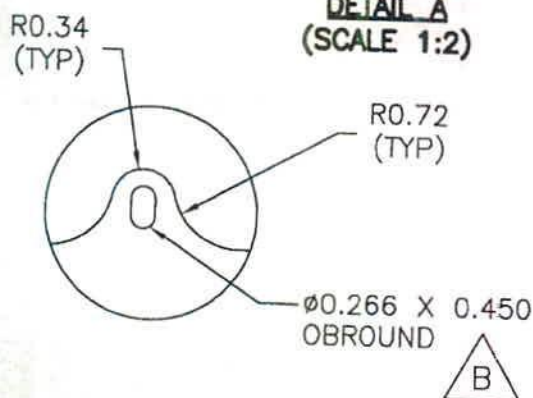
D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

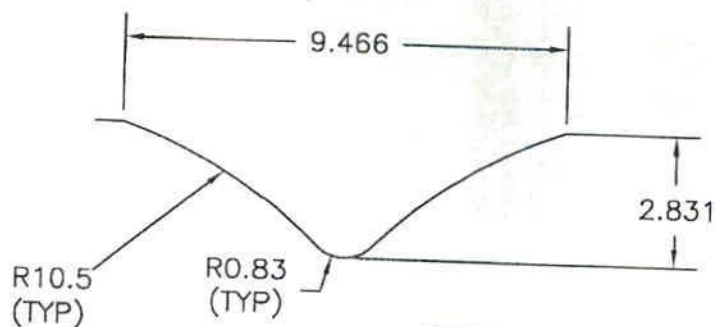
DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	DRAWING NO.	D3315	REV. B
		TITLE	WEARPLATE	SHEET 4 OF 4
				SCALE
				NTS

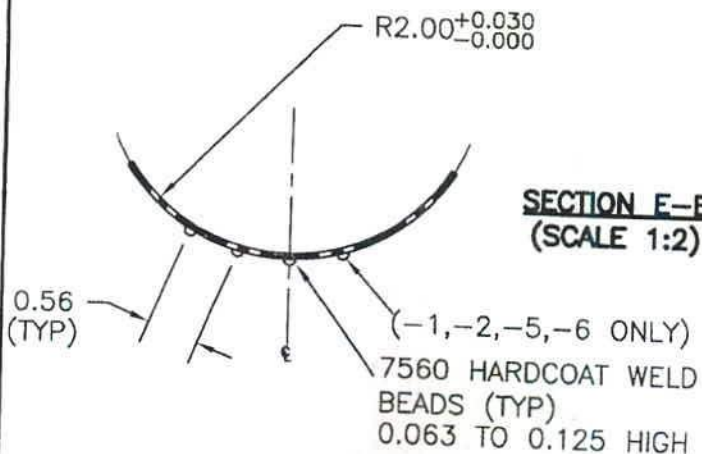
DETAIL A
(SCALE 1:2)



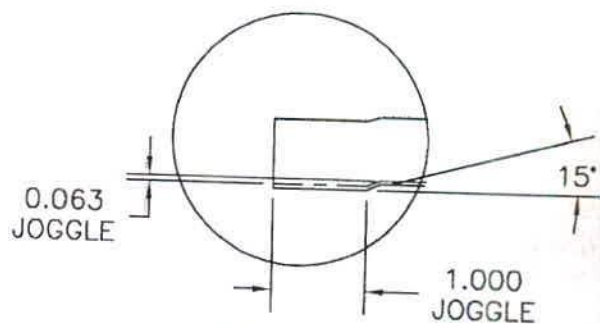
DETAIL B
(SCALE 1:4)



SECTION E-E
(SCALE 1:2)



DETAIL D
(SCALE 1:2)



SECTION F-F
(SCALE 1:2)

